

Work Order ID 122951

Tuesday, July 29, 2014 2:26:45 PM

646.3910
B122951
REV. N/C

122951

Page 1

Item ID: 646.3910

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 7/29/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 40.00

40

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan: wm

Date: 7/30/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3900

N/C

110

0.00

110

Waterjet

FLOW CNC Waterjet

Spring .020

Memo

1-Cut as per Dwg

Dwg Rev: NC

Prog Rev: NC

2-Deburr if necessary

0.00

60

DAS

46

9-89

14/08/23

PTO →

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

60

DAS

46

9-89

14/08/23

DQA:

Date:

15/05/05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/05/01

Work Order update only ☐

Work Order: <u>122951</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>646,3910</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. <u>15-4851</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-10-2	100	60	Corrosion found on all parts.		Scrap + destroy.	DAS 23 9-89	DAS 9 9-89	DAS 9 9-89
Doc/Data						AND Replace.			
Equip/Tooling						Recut			
Handling/Pre						B# 130477.			
Material						Qty x 60.			
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☒ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 122951***122951***

Page 2

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N900040100Setup Start ***NS1***

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Stop ***NS2***

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Start Qty: 40.00

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Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

P/B → DAS
38
9-89

OCT 28 2014

140

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

140

Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 26392

C& 14/11/05 60

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

60x 80/5-01-29

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>122951</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>646-3910</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. <u>15-4852</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Large amounts of Rust/Corrosion Found on all Parts.	DAS 16 7-89	SCRAP + Destroy AND Replace.	DAS 23 9-89 14-10-27	DAS 33 9-89	DAS 16 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☒ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 122951

Tuesday, July 29, 2014 2:26:45 PM

122951

Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

MAR 04 2015

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

DAS
27
9-29

MAR 05 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

1503-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, July 29, 2014 2:26:44 PM

Page 1

Work Order ID: 122951

122951

Parent Item: 646.3910

646.3910

Parent Item Name: Shim

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020		Purchased		No		110	sf	10.2500	0.03	1.263156			
MC1095S 020												DAS 46 9-89	14/08/23
C1095 Blue Tempered Spring Steel Sheet .020													

Location

Loc Qty

Loc Code

MAT022

10.25

~~122537~~

5.4

m126423

4.85

~~31~~

m 130477

m 130477

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

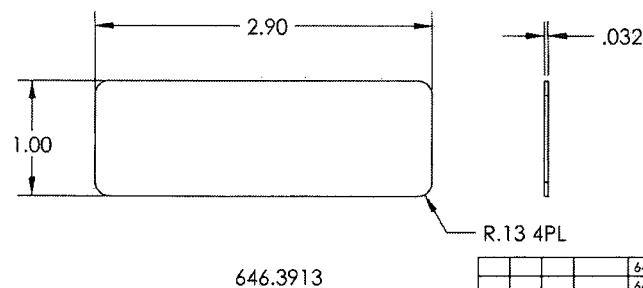
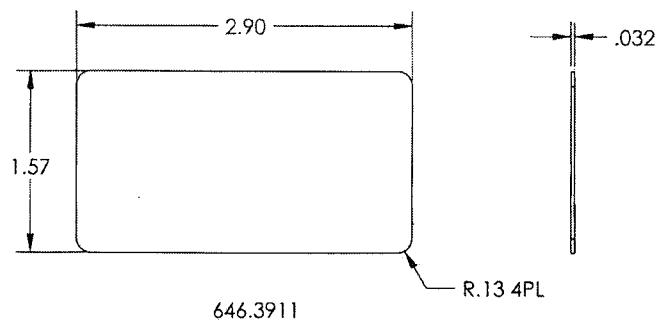
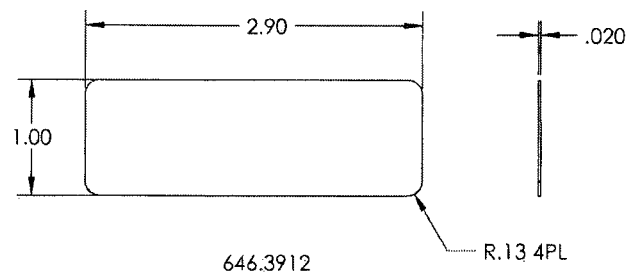
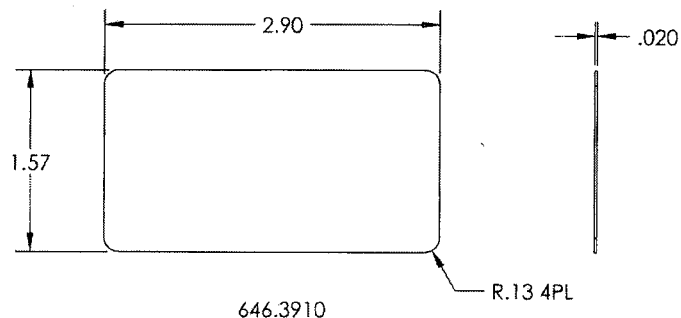
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROV.

1 MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL

2 FINISH: CAD PLATE PER QQ-P-416 TYP II CL2

3. IDENTIFY IAW MPP-120



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122951
7/30/14 Wm

				646.3913	SHIM	△	△
				646.3912	SHIM	△	△
				646.3911	SHIM	△	△
				646.3910	SHIM	△	△
	FIND #		PART #	DESCRIPTION	MAT'L		SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
646.4000				2608 TEMPLE HEIGHTS DR.			
				OCEANSIDE, CA 92056-3512			(760)724-5300
				SHIM			
				SIZE	CAGE CODE	SWC. ING.	REV.
				8	07M3Z6	646.3900	N/C
				SCALE	NONE		SHEET 1 OF 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26392

Purchase Order Date 11/5/2014

PO Print Date 11/5/2014

Page Number 3 of 4

Order From :

VC-CAD002

Ship To : DART AEROSPACE LTD

CADORATH COATING
2150 LOGAN AVE.
WINNIPEG, MB R2R 0J2
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

204 633 9420

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total:

\$330.00

6 122951 646.3910 SHIM 11/21/2014
Yes
11/21/2014

60.00 ✓

\$6.60

\$396.00

FINISH: CAD PLATE PER QQ-P-416 TYPE II CLASS 2

PART ARE MADE FROM SHIM STOCK, C1095 BLUE TEMPERED SPRING STEEL

SP15-01-29

Line Total:

\$396.00

7 71401-45 PROCUREMENT 11/21/2014
QUALITY CLAUSES

1.00

\$0.00

\$0.00

No

Procurement Quality Clauses

11/21/2014

A005 right of entry

A012 chemical and physical test report

A021 dart aerospace processing

A024 process certifications

A026 certification of material conformance

A043 retention of quality documents

Note:

11/5/2014

Packing Slip



Cadorth Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

S74889

Sold To:

Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
26392	Nov-15-2014	NET 30 DAYS	10071 6547 RT0001		Jan-28-2015

Item # Qty P/N & Description

1	4 EA	SHIM	S/N
		P/N 646.3913	W/O 140937
2	48 EA	SHIM	S/N
		P/N 646.3911	W/O 140938
3	92 EA	SHIM	S/N
		P/N 646.3913	W/O 140939
4	50 EA	SHIM	S/N
		P/N 646.3912	W/O 140940
5	50 EA	SHIM	S/N
		P/N 646.3912	W/O 140941
6	60 EA	SHIM	S/N
		P/N 646.3910	W/O 140942

✓
122951 SP 15-01-29.

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jan-28-2015

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 140942

INVOICE #: 74889

**CONTRACT OR
PURCHASE ORDER #** 26392

DESCRIPTION: SHIM

QTY 60 ✓

P/N # 646.3910 ✓

S/N #

SP15-01-29

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:

